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(54) **METHODS AND SYSTEMS FOR OPERATING A FLEET OF PUMPS**

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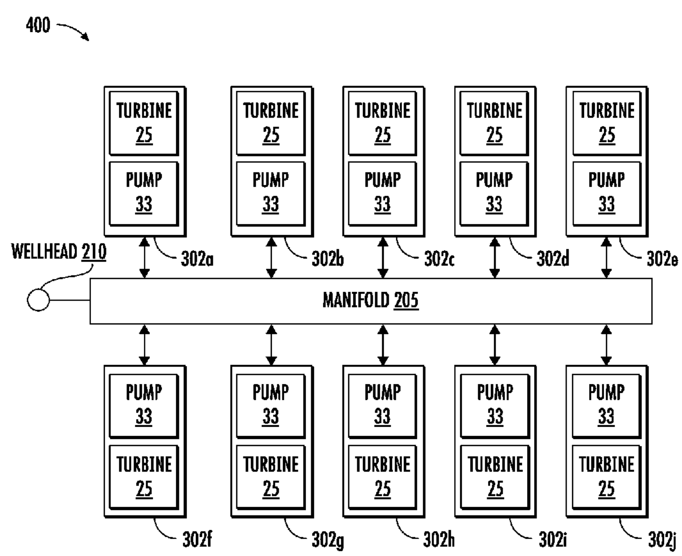
(57) **ABSTRACT**

A system and method for operating a fleet of pumps for a turbine driven fracturing pump system used in hydraulic fracturing is disclosed. In an embodiment, a method of operating a fleet of pumps associated with a hydraulic fracturing system includes receiving a demand Hydraulic Horse Power (HHP) signal. The demand HHP signal may include the Horse Power (HP) required for the hydraulic fracturing system to operate and may include consideration for frictional and other losses. The method further includes operating all available pump units at a percentage of rating below Maximum Continuous Power (MCP) level, based at least in part on the demand HHP signal. Furthermore, the method may include receiving a signal for loss of power from one or more pump units. The method further includes operating one or more units at MCP level and operating one or more units at Maximum Intermittent Power (MIP) level to meet the demand HHP signal.

28 Claims, 7 Drawing Sheets



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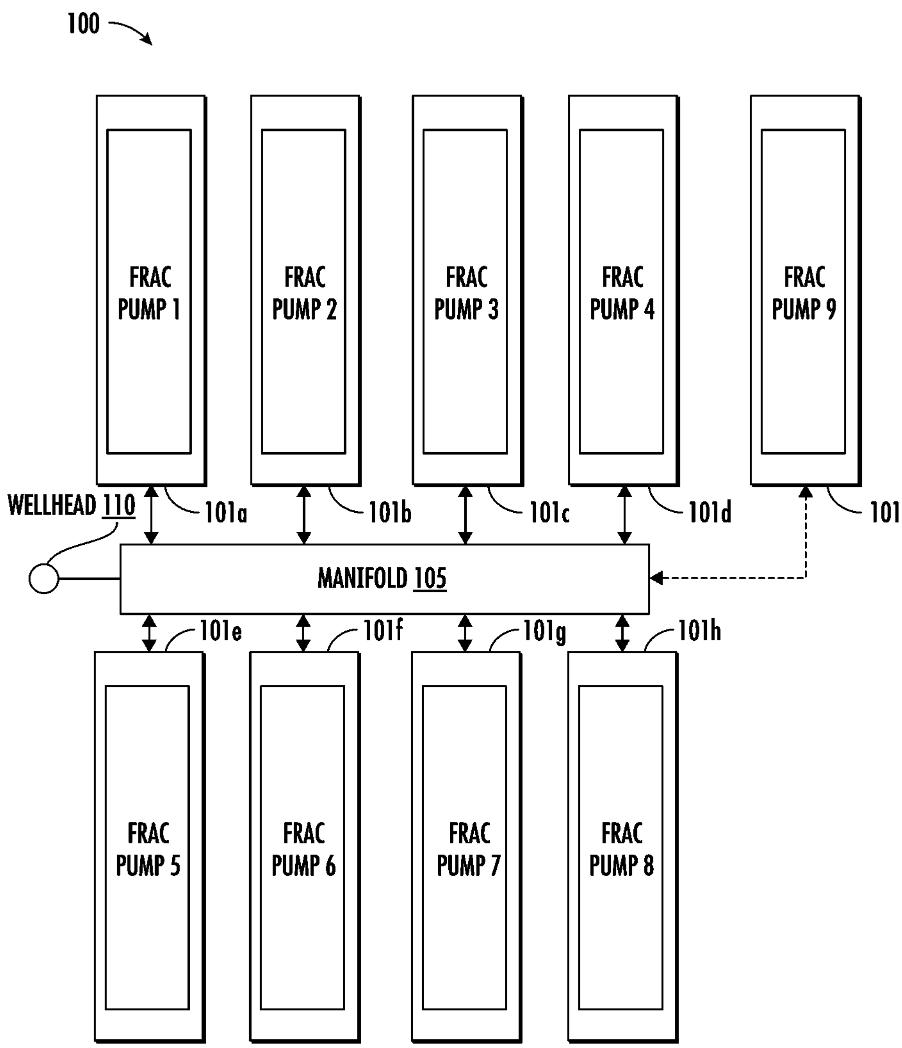

FIG. 1
PRIOR ART

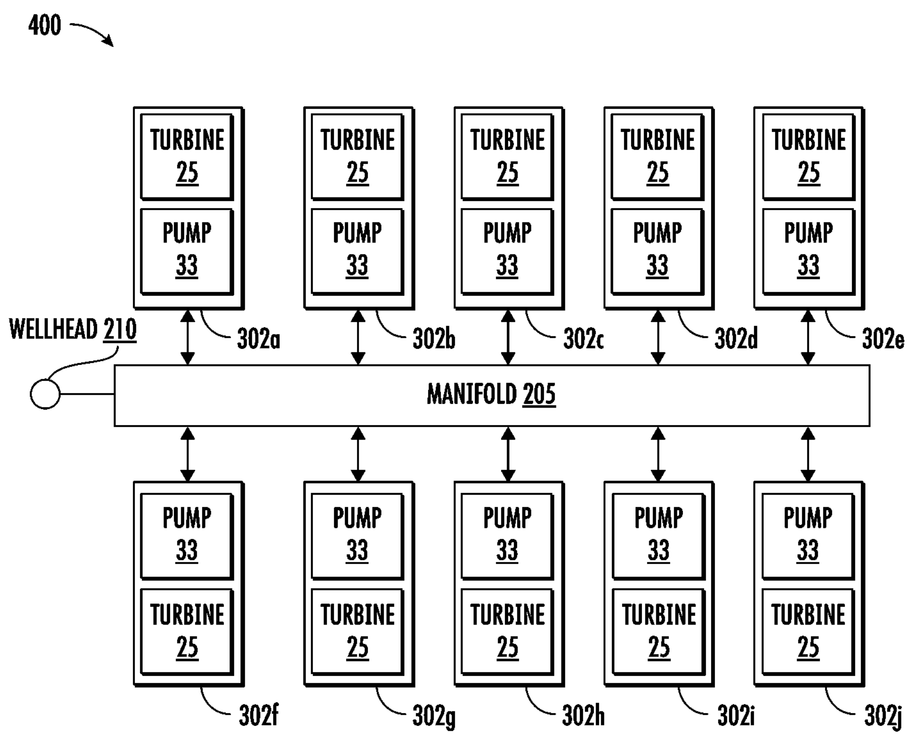
400
TURBINE 25
PUMP 33
302a
302b
302c
302d
302e
WELLHEAD 210
MANIFOLD 205
302f
302g
302h
302i
302j

FIG. 2

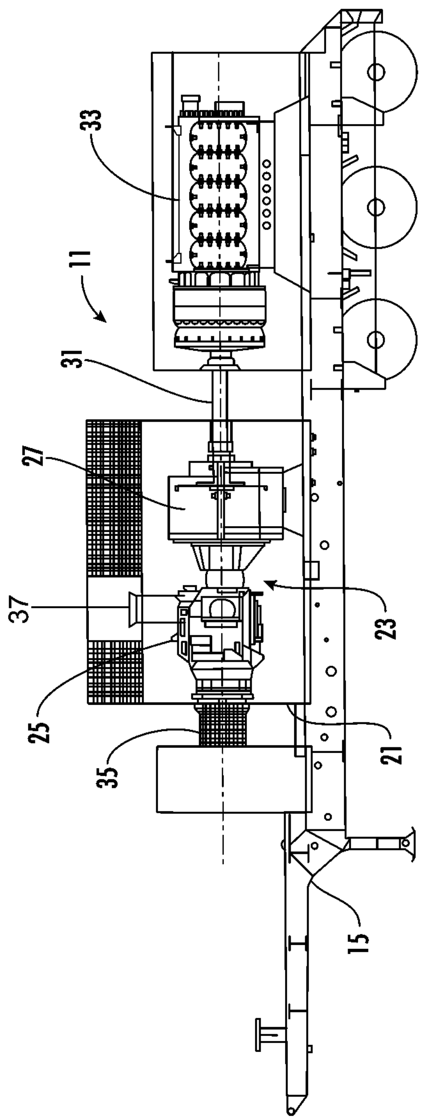

FIG. 3

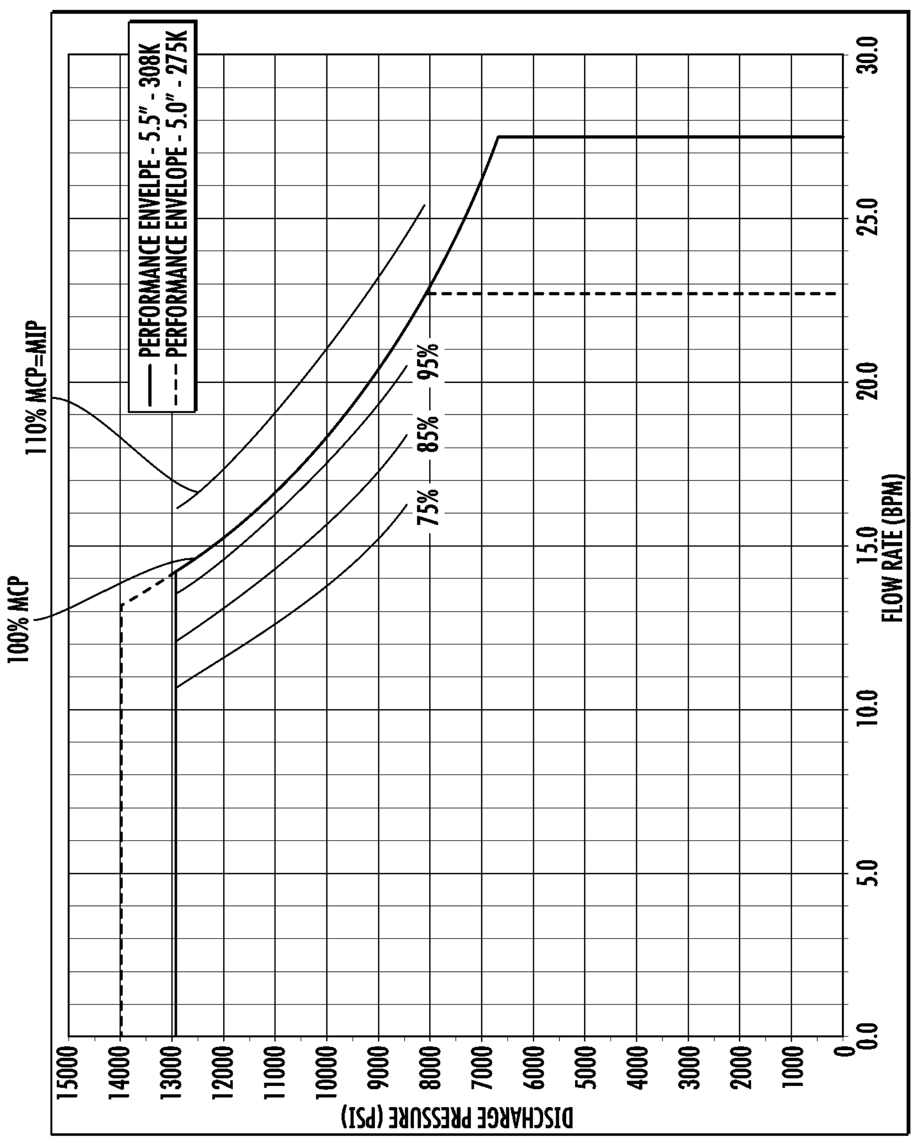
PERFORMANCE ENVELPE - 5.5" - 308K
PERFORMANCE ENVELOPE - 5.0" - 275K
110% MCP=MIP
100% MCP
75%
85%
95%
DISCHARGE PRESSURE (PSI)
FLOW RATE (BPM)
0
1000
2000
3000
4000
5000
6000
7000
8000
9000
10000
11000
12000
13000
14000
15000
0.0
5.0
10.0
15.0
20.0
25.0
30.0

FIG. 4

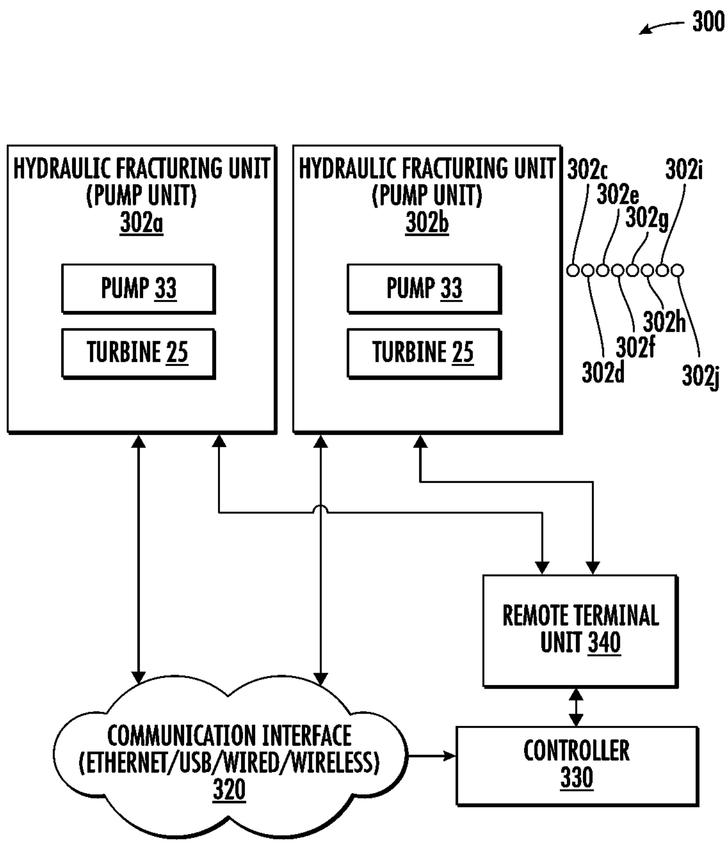
300
HYDRAULIC FRACTURING UNIT (PUMP UNIT) 302a
PUMP 33
TURBINE 25
HYDRAULIC FRACTURING UNIT (PUMP UNIT) 302b
PUMP 33
TURBINE 25
302c
302e
302g
302i
302h
302f
302d
302j
REMOTE TERMINAL UNIT 340
COMMUNICATION INTERFACE (ETHERNET/USB/WIRED/WIRELESS) 320
CONTROLLER 330

FIG. 5

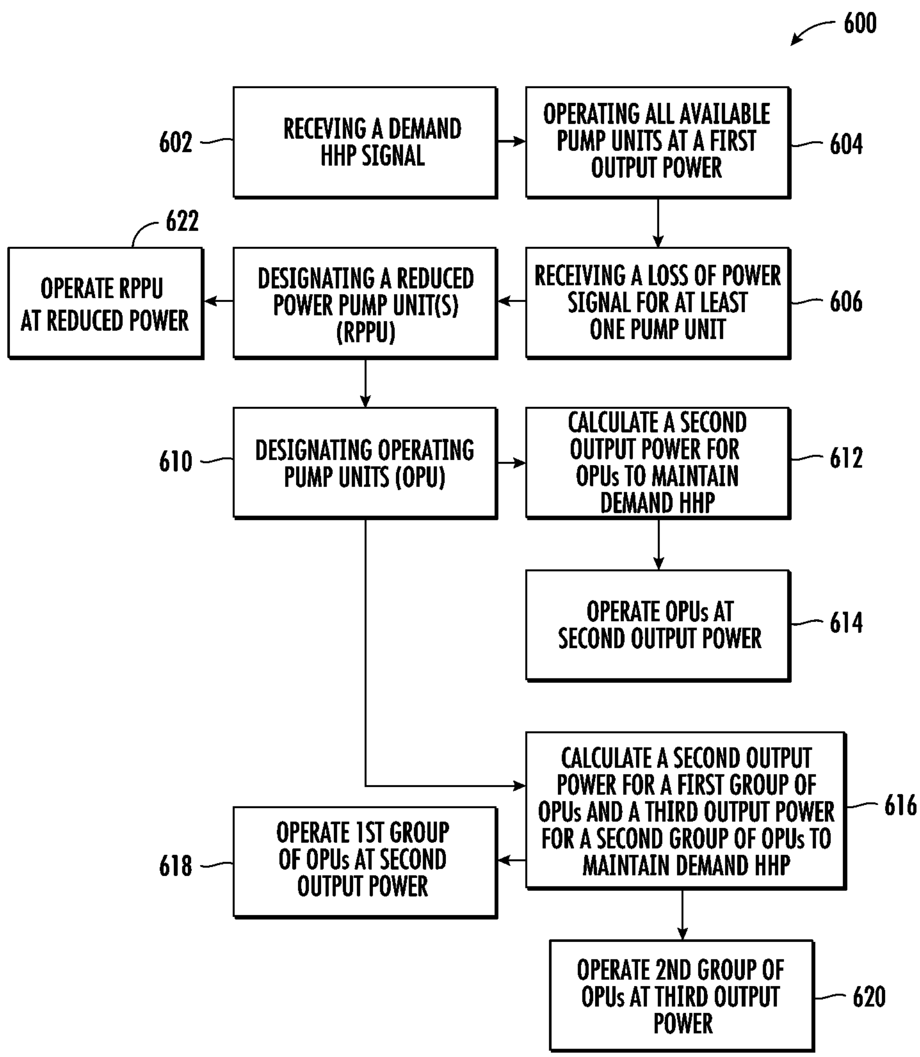
600
602
RECEVING A DEMAND HHP SIGNAL
OPERATING ALL AVAILABLE PUMP UNITS AT A FIRST OUTPUT POWER
604
622
OPERATE RPPU AT REDUCED POWER
DESIGNATING A REDUCED POWER PUMP UNIT(S) (RPPU)
RECEIVING A LOSS OF POWER SIGNAL FOR AT LEAST ONE PUMP UNIT
606
610
DESIGNATING OPERATING PUMP UNITS (OPU)
CALCULATE A SECOND OUTPUT POWER FOR OPUs TO MAINTAIN DEMAND HHP
612
OPERATE OPUs AT SECOND OUTPUT POWER
614
CALCULATE A SECOND OUTPUT POWER FOR A FIRST GROUP OF OPUs AND A THIRD OUTPUT POWER FOR A SECOND GROUP OF OPUs TO MAINTAIN DEMAND HHP
616
618
OPERATE 1ST GROUP OF OPUs AT SECOND OUTPUT POWER
OPERATE 2ND GROUP OF OPUs AT THIRD OUTPUT POWER
620

FIG. 6

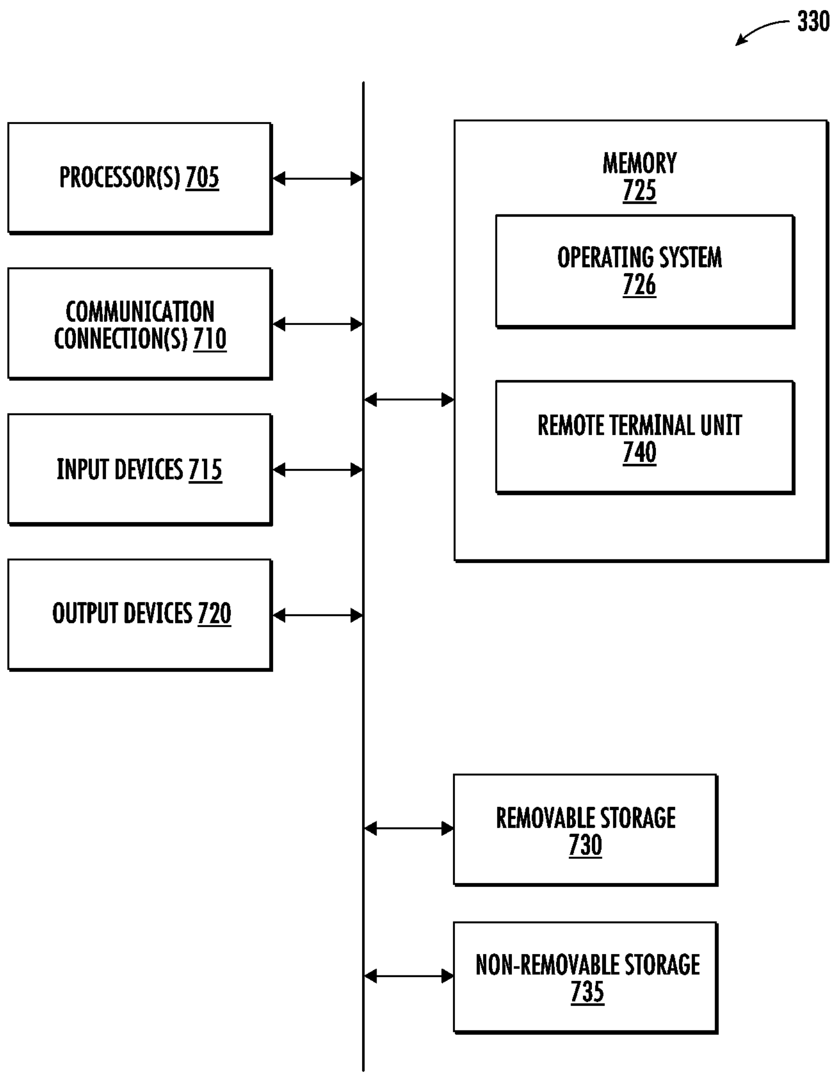
330
PROCESSOR(S) 705
COMMUNICATION CONNECTION(S) 710
INPUT DEVICES 715
OUTPUT DEVICES 720
MEMORY 725
OPERATING SYSTEM 726
REMOTE TERMINAL UNIT 740
REMOVABLE STORAGE 730
NON-REMOVABLE STORAGE 735

FIG. 7

METHODS AND SYSTEMS FOR OPERATING A FLEET OF PUMPS

CROSS REFERENCE TO RELATED APPLICATIONS

This application claims the benefit of and priority to U.S. Provisional Patent Application No. 62/899,951, which was filed on Sep. 13, 2019, and hereby is incorporated by reference for all purposes as if presented herein in its entirety.

BACKGROUND OF THE DISCLOSURE

This disclosure relates to operating a fleet of pumps for hydraulic fracturing and, in particular, to systems and methods for operating a directly driven turbine fracturing pump system for hydraulic fracturing application.

Traditional Diesel fracturing pumping fleets have a large footprint and often need additional auxiliary equipment to achieve the horsepower required for hydraulic fracturing. FIG. **1** shows a typical pad layout for a fracturing pump system **100** including fracturing or frac pumps **101***a* through **101***i*, with the pumps all being driven by a diesel powered engine and operatively connected to a manifold **105** that is operatively connected to a wellhead **110**. By way of an example, in order to achieve a maximum rated horsepower of 24,000 HP, a quantity of eight (8) 3000 HP pumping units (**101***a*-**101***h* or frac pump **1** to frac pump **8**) may be required as well as an additional one (1) spare unit (**101***i* or frac pump **9**) that may be readily brought online if one of the operating units is brought off line for either maintenance purposes or for immediate repairs. The numbers above are provided by way of an example and do not include frictional and other losses from prime mover to the pumps.

The layout as indicated in FIG. **1** requires a large footprint of service equipment, including hoses, connections, assemblies and other related equipment that may be potential employee hazards. Additionally, the spare unit, such as the one indicated by **101***i* in FIG. **1**, may need to be kept on standby so that additional fuel may be utilized, thereby adding further equipment requirements to the footprint that may be yet further potential employee hazards.

Accordingly, Applicant has recognized that a need exists for more efficient ways of managing power requirement for a hydraulic fracturing fleet while minimizing equipment layout foot print. The present disclosure addresses these and other related and unrelated problems in the art.

SUMMARY OF THE DISCLOSURE

According to one embodiment of the disclosure, a method of operating a plurality of pump units associated with a high-pressure, high-power hydraulic fracturing assembly is provided. Each of the pump units may include a turbine engine, a driveshaft, a gearbox connected to the turbine engine and driveshaft for driving the driveshaft, and a pump connected to the driveshaft. The method may include receiving a demand hydraulic horse power (HHP) signal for operation of the hydraulic fracturing assembly. Based at least in part on the demand HHP signal, the method may include operating all available pump units of the plurality of pump units at a first output power to achieve the demand HHP. The method may include receiving a loss of power signal for at least one pump unit of the plurality of pump units during operation of the plurality of pump units, and after receiving the loss of power signal, designating the at

least one pump unit as a reduced power pump unit (RPPU) and the remaining pump units as operating pump units (OPU). The method may further include operating at least one of the OPUs at a second output power to meet the demand HHP signal for operation of the hydraulic fracturing assembly. The first output power may be in the range of approximately 70% to 100% of a maximum continuous power (MCP) level of the plurality of pump units, the second output power may be greater than the first output power and may be in the range of approximately 70% of the MCP level to approximately a maximum intermittent power (MIP) level of the plurality of pump units.

According to another embodiment of the disclosure, a system is disclosed to control operation of a plurality of pump units associated with a hydraulic fracturing assembly. Each of the pump units may include a turbine engine connected to a gearbox for driving a driveshaft, and a pump connected to the drive shaft. The system includes a controller in communication with the plurality of pump units. The controller may include one or more processors and memory having computer-readable instructions stored therein and may be operable by the processor to receive a demand hydraulic horse power (HHP) signal for the hydraulic fracturing assembly. Based at least in part on the demand HHP signal, the controller may operate all available pump units of the plurality of pump units at a first output power to achieve the demand HHP, and may receive a loss of power signal from at least one pump unit of the plurality of pump units. After receiving the loss of power signal, the controller may designate the at least one pump unit as a reduced power pump unit (RPPU), and designate the remaining pump units as operating pump units (OPU). The controller may further operate one or more of the OPUs at a second output power to meet the demand HHP signal of the hydraulic fracturing system. The first output power may be in the range of approximately 70% to 100% of a maximum continuous power (MCP) level of the plurality of pump units. The second output power may be greater than the first output power and may be in the range of approximately 70% of MCP level to approximately a maximum intermittent power (MIP) level of the plurality of pump units.

Those skilled in the art will appreciate the benefits of various additional embodiments reading the following detailed description of the embodiments with reference to the below-listed drawing figures. It is within the scope of the present disclosure that the above-discussed aspects be provided both individually and in various combinations.

BRIEF DESCRIPTION OF THE FIGURES

According to common practice, the various features of the drawings discussed below are not necessarily drawn to scale. Dimensions of various features and elements in the drawings may be expanded or reduced to more clearly illustrate the embodiments of the disclosure.

FIG. **1** is a schematic diagram of a typical prior art fracturing pad layout for a hydraulic fracturing application according to the prior art.

FIG. **2** is a schematic diagram of a layout of a fluid pumping system according to an embodiment of the disclosure.

FIG. **3** is a schematic diagram of a directly driven turbine (DDT) pumping unit used in the fluid pumping system of FIG. **2** according an embodiment of the disclosure.

FIG. **4** is a pump operating curve for a DDT pumping unit of FIG. **3**.

FIG. **5** is a schematic diagram of a system for controlling the fluid pumping system of FIG. **2**.

FIG. **6** is a flowchart of a method for operating a fleet of pumps in a DDT fluid pumping system according to an embodiment of the disclosure.

FIG. **7** is a schematic diagram of a controller configured to control operation of the DDT fluid pumping system according to an embodiment of the disclosure.

Corresponding parts are designated by corresponding reference numbers throughout the drawings.

DETAILED DESCRIPTION

Generally, this disclosure is directed to methods and systems for controlling a fleet of DDT pumping units **11** (FIG. **3**) as part of a high-pressure, high-power, fluid pumping system **400** (FIG. **2**) for use in hydraulic fracturing operations. The systems and method of the present disclosure, for example, help reduce or eliminate the need for a spare pumping unit to be associated with the fluid pumping system **400**, among other features.

FIG. **3** illustrates a schematic view of a pumping unit **11** for use in a high-pressure, high power, fluid pumping system **400** (FIG. **2**) for use in hydraulic fracturing operations according to one embodiment of the disclosure. FIG. **2** shows a pad layout of the pumping units **11** (indicated as **302***a* thru **302***j*) with the pumping units all operatively connected to a manifold **205** that is operatively connected to a wellhead **210**. By way of an example, the system **400** is a hydraulic fracturing application that may be sized to deliver a total Hydraulic Horse Power (HHP) of 41,000 to the wellhead **210** as will be understood by those skilled in the art. In the illustrated embodiment, a quantity of ten pumping units **11** are used, but the system **400** may be otherwise configured to use more or less than then pumping units without departing from the disclosure. As shown in FIG. **3**, each of the pumping units **11** are mounted on a trailer **15** for transport and positioning at the jobsite. Each pumping unit **11** includes an enclosure **21** that houses a direct drive unit (DDU) **23** including a gas turbine engine (GTE) **25** operatively connected to a gearbox **27**. The pumping unit **11** has a driveshaft **31** operatively connected to the gearbox **27**. The pumping unit **11**, for example, may include a high-pressure, high-power, reciprocating positive displacement pump **33** that is operatively connected to the DDU **23** via the driveshaft **31**. In one embodiment, the pumping unit **11** is mounted on the trailer **15** adjacent the DDU **23**. The trailer **15** includes other associated components such as a turbine exhaust duct **35** operatively connected to the gas turbine engine **25**, air intake duct **37** operatively connected to the gas turbine, and other associated equipment hoses, connections, etc. to facilitate operation of the fluid pumping unit **11**. In one embodiment, the gas turbine engine **25** may operate on primary fuel, which may include gas fuels, such as, for example, compressed natural gas (CNG), natural gas, field gas or pipeline gas, and on secondary fuel, which may include liquid fuels, such as, for example, #2 Diesel or Bio-fuels.

In an embodiment, the gas turbine engine **25** may be a dual shaft, dual fuel turbine with a rated shaft horsepower (SHP) of 5100 at standard conditions, or other suitable gas turbine. The gearbox **27** may be a reduction helical gearbox that has a constant running power rating of 5500 SHP and intermittent power output of 5850 SHP, or other suitable gearbox. The driveshaft **31** may be a 390 Series, GWB Model 390.80 driveshaft available from Dana Corporation, or other suitable driveshaft. In one example, the pump **33** may be a high-pressure, high-power, reciprocating positive displacement pump rated at 5000 HP, but the pump may be rated to an elevated horsepower above the gas turbine engine **25**, e.g., 7000 HP, or may be otherwise sized without departing from the disclosure.

In one embodiment, for example, the desired HHP of the fluid pumping system **400** may be 41,000 HHP and the fluid pumping system **400** having ten pump units **302***a* thru **302***j* that deliver the 41,000 HHP by each operating at an operating power below a Maximum Continuous Power (MCP) rating of each the pump unit. The Maximum Continuous Power (MCP) level of the pump corresponds to the maximum power at which the individual pump units **302***a* thru **302***j* may sustain continuous operation without any performance or reliability penalties. In one example, the ten pump units **302***a* thru **302***j* may operate at approximately 80% MCP to deliver the 41,000 HHP required for the fluid pumping system **400**. The Maximum Intermittent Power (MIP) level of a pump unit **302***a* thru **302***j* is an elevated operating output level that the pump unit may operate intermittently throughout its operating life without excessive damage to the pump unit. The operation of a pump unit **302***a* thru **302***j* at or above the MIP power level may incur penalties associated with pump unit life cycle estimates and other warranties. The MIP power level for a DDT pump unit **302***a* thru **302***j* may be attained by over-firing the turbine engine **25** associated with the pump unit **302***a* thru **302***j* or by other means of operation. The MIP power level of the pump units **302***a* thru **302***j* is typically an amount above the MCP level and may typically range from 101% of rated MCP to 110% of rated MCP. In an embodiment of the disclosure, the MIP level may be set at 107% of rated power. In other embodiments, the MIP level may be greater than 110% of rated MCP without departing from the disclosure.

FIG. **4** illustrates a graph of a discharge pressure vs. flow rate curve for exemplary pump units **302***a* thru **302***j* of the present disclosure. As indicated in FIG. **4**, the pump units **302***a*-**302***j* (as an example, 5000 HP pump units are shown) may operate in typical operating range of approximately 75% to 95% of MCP to deliver the required HHP of the fluid pumping system **400** for a particular well site. The corresponding percentage of MCP of the pump units **302***a*-**302***j* is indicated by the 75%, 85%, and 95% lines that are parallel to the 100% MCP line. Any operation of the pump unit **302***a* thru **302***j* beyond the 100% MCP curve should be an intermittent occurrence to avoid damage to the pump unit. In one example, the MIP is indicated at 110% MCP, but the MIP may be other percentages to the right of the 100% MCP line without departing from the disclosure. One or more of these parallel curves below the 100% MCP line may demonstrate the percentage of the maximum pump power output that may be required to maintain the HHP of the fluid pumping system **400**. The two lines, i.e., solid line (5.5") and dashed line (5.0") respectively correspond to the diameter of a plunger being used in a reciprocating pump. As will be understood by those skilled in the art, some pump manufacturer may make pumps with plunger/packing assemblies that vary from 4.5" to 5.5", for example. When the pumps run at equal power outputs, there is a change or difference in a rod load (force) on the plunger due to differences in an elevated surface area, e.g., which is why one may have 308,000 lbs/f for a 5.5" plunger as compared to 275,000 lbs for a 5" plunger. A pump, in these situations for example, only may handle a certain amount of total HHP with either an elevated pressure (which is achieved with a larger plunger) and a compromised rate, or vice versa, as will be understood by those skilled in the art. In some embodiments, the 5" plunger may be desirable, and the different solid black lines are indicating performance at certain HHP outputs. As discussed below, upon a loss of power situation of one of the pumps units **302***a* thru **302***j*, the other pump units may operate above the desired/normal pump power output to maintain the needed HHP of the fluid pumping system **400**.

FIG. **5** illustrates a schematic diagram of a system **300** for controlling operation of the fleet of pumps **302***a* thru **302***j* forming the directly Driven Turbine (DDT) pumping system **400** of the present disclosure. The system **300** controls the one or more hydraulic fracturing pump units **302***a* thru **302***j* that operate to provide the required HHP of the fluid pumping system **400**. Only two pump units **302***a*, **302***b* are illustrated in detail in FIG. **3**, but it is understood that all of the pump units will be controlled by the control system **300** to operate in a similar manner.

As shown in FIG. **5**, the system **300** may also include one or more controllers, such as the controller or control system **330**, which may control operations of the DDT pumping system and/or the components of the DDT pumping system. In an embodiment, the controller **330** may interface with one or more Remote Terminal Units (RTU) **340**. The RTU **340** may include communication and processing interfaces as well as collect sensor data from equipment attached to the RTU **340** and transmit them to the control system **330**. In an embodiment, the control system **330** may act as supervisory control for several RTUs **340**, each connected to an individual pump unit **302***a* thru **302***i*. The control system **330** and/or the RTU **340** may include one or more industrial control system (ICS), such as, for example, Supervisory Control and Data Acquisition (SCADA) systems, distributed control systems (DCS), and programmable logic controllers (PLCs), or other suitable control systems and/or control features without departing from the disclosure.

The controller **330** may be communicatively coupled to send signals and receive operational data from the hydraulic fracturing pump units **302***a* thru **302***j* via a communication interface **320**, which may be any of one or more communication networks such as, for example, an Ethernet interface, a universal serial bus (USB) interface, or a wireless interface, or any other suitable interface. In certain embodiments, the controller **330** may be coupled to the pump units **302***a* thru **302***j* by way of a hard wire or cable, such as, for example, an interface cable. The controller **330** may include a computer system having one or more processors that may execute computer-executable instructions to receive and analyze data from various data sources, such as the pump units **302***a* thru **302***j*, and may include the RTU **340**. The controller **330** may further provide inputs, gather transfer function outputs, and transmit instructions from any number of operators and/or personnel. The controller **330** may perform control actions as well as provide inputs to the RTU **340**. In other embodiments, the controller **330** may determine control actions to be performed based on data received from one or more data sources, for example, from the pump units **302***a* thru **302***j*. In other instances, the controller **330** may be an independent entity communicatively coupled to the RTU **340**.

FIG. **6** shows one exemplary embodiment of a flow diagram of a method **600** of operating the plurality of pumps **302***a* thru **302***j* that may be executed by the controller **330**. The controller **330** includes a memory that contains computer-executable instructions capable of receiving signals from the sensors associated with the pump units **302***a* thru **302***j*. As shown in FIG. **6**, a demand Hydraulic Horse Power (HHP) signal from a master controller or from a controller associated with the fracturing process is received by the controller **330** (Step **602**). By way of an example, the demand HHP signal may be a signal corresponding to the demanded power for pumping stimulation fluid associated with the fracturing process. When the demand HHP signal is received, the controller **330** directs operation of all available pump units **302***a* thru **302***j* at a first output power (Step **604**). The first output power may be at a percentage rating at or below the MCP level of the pump units **302***a* thru **302***j*. In one example, the first output power may be in the range of approximately 70% to 100% of MCP. By way of an example, the controller **330** may command all the available pump units **302***a* thru **302***j* to operate at 100% of rated MCP based on the demand HHP Signal. In other instances, the controller **330** may command the available pump units **302***a* thru **302***j* to operate at a rated MCP of 70%, 80%, or 95%, based on the requested HHP demand. Alternatively, the controller **330** may command the available pump units **302***a* thru **302***j* to operate at a rated MCP below 70%, or any other rated MCP below 100% without departing from the disclosure.

During operation of the fluid pumping system **300**, the controller **330** will monitor the operation of the pumping units **302***a* thru **302***j* including the power utilization and overall maintenance health of each pumping unit. The controller **330** may receive a signal for loss of power from one or more pumping units **302***a* thru **302***j* (Step **606**). The loss of power signal may occur if one or more of the pump units **302***a* thru **302***j* loses power such that the detected output power of a respective pump is below the first output power. Further, the loss of power signal may occur if a respective pump unit **302***a* thru **302***j* is completely shut down and experiences a loss of power for any reason (e.g., loss of fuel to turbine **25**). Further, one or more of the pump units **302***a* thru **302***j* may be voluntary taken out of service for routine service/maintenance issues including routine maintenance inspection or for other reasons. Upon receiving the loss of power signal, the controller **330** may designate one or more of the pump units **302***a* thru **302***j* as a Reduced Power Pump Unit (RPPU) (Step **608**) and designate the remaining pump units as Operating Pump Units (OPUs) (Step **610**). In one embodiment, the controller **330** will calculate a second output power at which the OPUs must operate to maintain the needed HHP of the fluid pumping system **400** based on the reduced operating power of the RPPU(s) (Step **612**). In one embodiment, the second output power is greater than the first output power and may be in the range of approximately 70% of the MCP level to approximately the MIP level for the pumping units. The controller **330** will revise the operating parameters of the OPUs to operate at the calculated second output power to maintain the HHP of the fluid pumping system **400** (Step **614**). The controller **330** continues to monitor the operation of the OPUs to maintain sufficient output of the fluid pumping units **302***a* thru **302***j* to meet the demand HHP for the system **400**.

In an alternative embodiment of the method of operation, it may be desired to operate some of the OPUs at different operating powers. In this instance, after designating the OPUs at step **610**, the controller **330** will calculate a second output power for a first group of OPUs and calculate a third output power for a second group of OPUs (step **616**). In one embodiment, both the second output power and the third output power is greater than the first output power, but one or both of the second output power and the third output power may be equal to or below the first output power without departing from the disclosure. Both the second output power and the third output power may be in the range of approximately 70% of the MCP level to approximately the MIP level for the pumping units. The controller **330** operates the first group of OPUs at the second output power (step **618**) and operates the second group of OPUs at the third output power (**620**) to maintain the sufficient output of the fluid pumping units **302***a* thru **302***j* to meet the demand HHP for the fluid pumping system **400**.

The controller **330** will monitor the time that any of the pump units **302***a* thru **302***j* are operated at a second output power or third output power that exceeds the MCP level or approaches or exceeds the MIP level. Operators will be notified when operation of the system **400** at these elevated levels of output power exceed parameters that necessitate a shutdown of the system to avoid failure of the pumping units **302***a* thru **302***j*. Care should be taken to remedy the situation that caused the loss of power signal so that all the pumping units **302***a* thru **302***j* may be returned to their normal output power to maintain the desired HHP of the system **400**.

In one embodiment, the loss of power signal received by the controller **330** at step **606** may indicate a reduction in the output power of one or more RPPUs and the controller will continue the operation of the detected RPPUs (step **622**) at a reduced power level below the first output power. Further, the loss of power signal received by the controller **330** may indicate a complete loss of power of one or more of the RPPUs **302***a* thru **302***j*. If a complete loss of power of one or more of the pumping units **302***a* thru **302***j* is detected, the second output power and/or third output power would be higher to accommodate for the total loss of power of one or more of the pumping units. In one embodiment, the controller **330** calculates the second output power and/or third output power for the OPUs **302***a*-**302***j* in the form of a flow adjustment needed for the OPUs. The second output power and/or third output power of the OPUs **302***a*-**302***j* may require operation of the OPUs at or above MIP level for a short period of time (e.g., 30 minutes) while the issues that triggered the loss of power signal (step **606**) is corrected.

In one embodiment, during the loss of one or more pump units **302***a*-**302***j*, the controller **330** may be able to meet the demand HHP by operating all of the OPUs at a second output power of 100% MCP level. In other embodiments, the controller **330** would be able to meet the demand HHP only by operating all of the OPUs **302***a*-**302***j* at a second output power at the MIP level (e.g., 107% of MCP level). In other embodiments, the controller **330** would be able to meet the demand HHP by operating the first group of OPUs **302***a*-**302***j* at a second output power at the MIP level and operating the second group of OPUs at a third output power at the MCP level.

By way of an example, for the ten pump unit system **400** shown in FIG. **2**, the controller **330** may be able to maintain the demand HHP when one of the ten pump units **302***a*-**302***j* is offline (designated the RPPU) by operating two of the OPUs at the MIP level and seven of the OPUs at the MCP level. In another example, the controller **330** may be able to operate three of the OPUs **302***a*-**302***j* at the MIP level and six of the OPUs at the MCP level. In another example, the controller may be able to operate one of the OPUs **302***a*-**302***j* at the MIP level and eight of the OPUs at the MCP level. In another example, the controller may be able to operate four of the OPUs **302***a*-**302***j* at the MIP level and five of the OPUs at the MCP level. The controller **330** may operate various other quantities of OPUs **302***a*-**302***j* operating at a second output power and/or third output power without departing from the disclosure.

FIG. **7** illustrates the controller **330** configured for implementing certain systems and methods for operating a fleet of pumps in accordance with certain embodiments of the disclosure. The controller **330** may include a processor **705** to execute certain operational aspects associated with implementing certain systems and methods for operating a fleet of pumps in accordance with certain embodiments of the disclosure. The processor **705** may communicate with a memory **725**. The processor **705** may be implemented and operated using appropriate hardware, software, firmware, or combinations thereof. Software or firmware implementations may include computer-executable or machine-executable instructions written in any suitable programming language to perform the various functions described. In one embodiment, instructions associated with a function block language may be stored in the memory **725** and executed by the processor **705**.

The memory **725** may be used to store program instructions, such as instructions for the execution of the method **600** described above or other suitable variations. The instructions are loadable and executable by the processor **705** as well as to store data generated during the execution of these programs. Depending on the configuration and type of the controller **330**, the memory **725** may be volatile (such as random access memory (RAM)) and/or non-volatile (such as read-only memory (ROM), flash memory, etc.). In some embodiments, the memory devices may include additional removable storage **730** and/or non-removable storage **735** including, but not limited to, magnetic storage, optical disks, and/or tape storage. The disk drives and their associated computer-readable media may provide non-volatile storage of computer-readable instructions, data structures, program modules, and other data for the devices. In some implementations, the memory **725** includes multiple different types of memory, such as static random access memory (SRAM), dynamic random access memory (DRAM), or ROM.

The memory **725**, the removable storage **730**, and the non-removable storage **735** are all examples of computer-readable storage media. For example, computer-readable storage media may include volatile and non-volatile, removable and non-removable media implemented in any method or technology for storage of information such as computer-readable instructions, data structures, program modules or other data. Additional types of computer storage media that may be present include, but are not limited to, programmable random access memory (PRAM), SRAM, DRAM, RAM, ROM, electrically erasable programmable read-only memory (EEPROM), flash memory or other memory technology, compact disc read-only memory (CD-ROM), digital versatile discs (DVD) or other optical storage, magnetic cassettes, magnetic tapes, magnetic disk storage or other magnetic storage devices, or any other medium which may be used to store the desired information and which may be accessed by the devices. Combinations of any of the above should also be included within the scope of computer-readable media.

Controller **330** may also include one or more communication connections **710** that may allow a control device (not shown) to communicate with devices or equipment capable of communicating with the controller **330**. The controller **330** may also include a computer system (not shown). Connections may also be established via various data communication channels or ports, such as USB or COM ports to receive cables connecting the controller **330** to various other devices on a network. In one embodiment, the controller **330** may include Ethernet drivers that enable the controller **130** to communicate with other devices on the network. According to various embodiments, communication connections **710** may be established via a wired and/or wireless connection on the network.

The controller **330** may also include one or more input devices **715**, such as a keyboard, mouse, pen, voice input device, gesture input device, and/or touch input device, or any other suitable input device. It may further include one or more output devices **720**, such as a display, printer, and/or speakers, or any other suitable output device. In other embodiments, however, computer-readable communication media may include computer-readable instructions, program modules, or other data transmitted within a data signal, such as a carrier wave, or other transmission.

In one embodiment, the memory **725** may include, but is not limited to, an operating system (OS) **726** and one or more application programs or services for implementing the features and aspects disclosed herein. Such applications or services may include a Remote Terminal Unit **340**, **740** for executing certain systems and methods for operating a fleet of pumps in a hydraulic fracturing application. The Remote Terminal Unit **340**, **740** may reside in the memory **725** or may be independent of the controller **330**, as represented in FIG. **3**. In one embodiment, Remote Terminal Unit **340**, **740** may be implemented by software that may be provided in configurable control block language and may be stored in non-volatile memory. When executed by the processor **705**, the Remote Terminal Unit **340**, **740** may implement the various functionalities and features associated with the controller **330** described in this disclosure.

As desired, embodiments of the disclosure may include a controller **330** with more or fewer components than are illustrated in FIG. **7**. Additionally, certain components of the controller **330** of FIG. **7** may be combined in various embodiments of the disclosure. The controller **330** of FIG. **7** is provided by way of example only.

In some embodiments, the sizing of downstream equipment (e.g., pump unit discharge piping, manifold, etc.) should be increased compared to that sizing of the standard power output downstream equipment of the pump units to take advantage at operating at the elevated output power of the pump unit during short term use. The pump unit power rating should be increased to allow for the maximum intermittent power of the engine. Further, the size and torque rating of the driveshaft and if applicable torsional vibration dampeners and flywheels also be considered when designing the power train.

Examples of such configurations in a dual shaft, dual fuel turbine engine with a rated shaft horse power of 5100 at standard ISO conditions is used in conjunction with a reduction Helical Gearbox that has a constant running power rating of 5500 SHP & an intermittent power output of 5850 SHP. The engine, gearbox assembly, and the drive shaft should be sized and selected to be able to meet the power and torque requirements at not only the constant running rating of the pump units but also the intermittent/increased loads. In one example, a 390.80 GWB driveshaft may be selected. The drive train may include torsional vibration dampeners as well as single mass fly wheels and their installation in the drive train is dependent on the results from careful torsional vibration analysis. The pump unit may be rated to an elevated horsepower above that of the engine. Common pumps on the market are rated at 7000 HP with the next lowest pump being rated to 5000 HP respectively. The sizing, selection, and assembly of such a drive train would allow reliable operation of the turbine engine above the 100% rated HP value with the resulting hydraulic horse power (HHP) produced being dependent on environmental and other conditions.

References are made to block diagrams of systems, methods, apparatuses, and computer program products according to example embodiments. It will be understood that at least some of the blocks of the block diagrams, and combinations of blocks in the block diagrams, may be implemented at least partially by computer program instructions. These computer program instructions may be loaded onto a general purpose computer, special purpose computer, special purpose hardware-based computer, or other programmable data processing apparatus to produce a machine, such that the instructions which execute on the computer or other programmable data processing apparatus create means for implementing the functionality of at least some of the blocks of the block diagrams, or combinations of blocks in the block diagrams discussed.

These computer program instructions may also be stored in a non-transitory computer-readable memory that may direct a computer or other programmable data processing apparatus to function in a particular manner, such that the instructions stored in the computer-readable memory produce an article of manufacture including instruction means that implement the function specified in the block or blocks. The computer program instructions may also be loaded onto a computer or other programmable data processing apparatus to cause a series of operational steps to be performed on the computer or other programmable apparatus to produce a computer implemented process such that the instructions that execute on the computer or other programmable apparatus provide task, acts, actions, or operations for implementing the functions specified in the block or blocks.

One or more components of the systems and one or more elements of the methods described herein may be implemented through an application program running on an operating system of a computer. They also may be practiced with other computer system configurations, including handheld devices, multiprocessor systems, microprocessor based or programmable consumer electronics, mini-computers, mainframe computers, and the like.

Application programs that are components of the systems and methods described herein may include routines, programs, components, data structures, and so forth that implement certain abstract data types and perform certain tasks or actions. In a distributed computing environment, the application program (in whole or in part) may be located in local memory or in other storage. In addition, or alternatively, the application program (in whole or in part) may be located in remote memory or in storage to allow for circumstances where tasks may be performed by remote processing devices linked through a communications network.

Although only a few exemplary embodiments have been described in detail herein, those skilled in the art will readily appreciate that many modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of the embodiments of the present disclosure. Accordingly, all such modifications are intended to be included within the scope of the embodiments of the present disclosure as defined in the following claims. In the claims, means-plus-function clauses are intended to cover the structures described herein as performing the recited function and not only structural equivalents, but also equivalent structures.

What is claimed is:

1. A method of operating a plurality of pump units associated with a high-pressure, high-power hydraulic fracturing assembly, each of the pump units including a turbine engine, a driveshaft, a gearbox connected to the turbine engine and driveshaft for driving the driveshaft, and a pump connected to the driveshaft, the method comprising:

receiving a demand hydraulic horse power (HHP) signal for operation of the hydraulic fracturing assembly;

based at least in part on the demand HHP signal, operating all available pump units of the plurality of pump units at a first output power to achieve the demand HHP;

receiving a loss of power signal for at least one pump unit of the plurality of pump units during operation of the plurality of pump units;

after receiving the loss of power signal, designating the at least one pump unit as a reduced power pump unit (RPPU) and the remaining pump units as operating pump units (OPU); and

operating at least one of the OPUs at a second output power to meet the demand HHP signal for operation of the hydraulic fracturing assembly,

the first output power being in the range of approximately 70% to 100% of a maximum continuous power (MCP) level of the plurality of pump units, the second output power being greater than the first output power and being in the range of approximately 70% of the MCP level to approximately a maximum intermittent power (MIP) level of the plurality of pump units.

2. The method of claim **1**, further comprising operating at least one of the OPUs at a third output power, the third output power being in the range of approximately 70% to approximately the MIP level.

3. The method of claim **2**, wherein the third output power is greater than the first output power.

4. The method of claim **2**, wherein the third output power is approximately equal to the first output power.

5. The method of claim **1**, wherein the at least one RPPU comprises one pump unit, and wherein the OPUs operating at the second output power comprise one or more less pump units than the plurality of pump units.

6. The method of claim **1**, wherein the at least one pump unit of the OPUs comprises all of the OPUs, and wherein the second output power comprises the MIP level.

7. The method of claim **1**, wherein the first output power is 100% of the MCP level.

8. The method of claim **1**, wherein the first output power is 90% of the MCP level.

9. The method of claim **8**, wherein the second output power is 107% of the MCP level.

10. The method of claim **9**, wherein the second output power is the MIP level.

11. The method of claim **1**, wherein the at least one pump unit of the OPUs comprises at least two pump units, and wherein the second output power comprises the MIP level.

12. The method of claim **1**, further comprising operating the at least one RPPU at a reduced output power below the first output power.

13. The method of claim **12**, wherein the reduced output power of the RRPU is approximately 20% less than the first output power.

14. The method of claim **1**, further comprising shutting down the at least one RPPU, and wherein the second output power is approximately the MIP level.

15. A system to control operation of a plurality of pump units associated with a hydraulic fracturing assembly, each of the pump units including a turbine engine, connected to a gearbox for driving a driveshaft, and a pump connected to the drive shaft, the system comprising:

a controller in communication with the plurality of pump units, the controller including one or more processors and memory having computer-readable instructions stored therein and operable by the processor to:

receive a demand hydraulic horse power (HHP) signal for the hydraulic fracturing assembly,

based at least in part on the demand HHP signal, operate all available pump units of the plurality of pump units at a first output power to achieve the demand HHP;

receive a loss of power signal from at least one pump unit of the plurality of pump units,

after receiving the loss of power signal, designate the at least one pump unit as a reduced power pump unit (RPPU), and

designate the remaining pump units as operating pump units (OPU), and operate one or more of the OPUs at a second output power to meet the demand HHP signal of the hydraulic fracturing system,

the first output power being in the range of approximately 70% to 100% of a maximum continuous power (MCP) level of the plurality of pump units, the second output power being greater than the first output power and being in the range of approximately 70% of MCP level to approximately a maximum intermittent power (MIP) level of the plurality of pump units.

16. The system of claim **15**, wherein after receiving the loss of power signal, the computer readable instructions are operable to operate at least one of the OPUs at a third output power, the third output power being in the range of approximately 70% to approximately the MIP level.

17. The system of claim **16**, wherein the third output power is greater than the first output power.

18. The system of claim **16**, wherein the third output power is approximately equal to the first output power.

19. The system of claim **16**, wherein the at least one RPPU comprises one pump unit, and wherein the OPUs comprise one less pump unit than the plurality of pump units.

20. The system of claim **16**, wherein the at least one pump unit of the OPUs comprises all of the OPUs, and wherein the second output power comprises the MIP level.

21. The system of claim **16**, wherein the first output power is 100% of the MCP.

22. The system of claim **21**, wherein the second output power 107% of the MCP level.

23. The system of claim **22**, wherein the second output power is the MIP level.

24. The system of claim **16**, wherein the first output power is 90% of the MCP level.

25. The system of claim **16**, wherein the at least one pump unit of the OPUs comprises at least two pump units, and wherein the second output power comprises the MIP level.

26. The system of claim **16**, wherein after receiving the loss of power signal, the computer readable instructions are operable to operate the at least one RPPU at a reduced output power below the first output power.

27. The system of claim **26**, wherein the reduced output power of the RRPU is approximately 20% less than the first output power.

28. The system of claim **16**, wherein after receiving the loss of power signal, the computer readable instructions are operable to shut down the at least one RRPU, and the second output power is approximately the MIP level.

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